

9

Date: Thursday, 1/17/2008 3:25:22 PM
 User: Kim Johnston

Process Sheet

Customer	CLJ-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID	
Job Number	36820A				
Estimate Number	10193				
P.O. Number	:		Part Number	: D2512	
This Issue	1/17/2008	S.O. No. :	Drawing Number	: D2512 REV D2	
Prsht Rev.	: NC		Project Number	:	
First Issue	1/1	Type : LARGE FAB ASSY	Drawing Revision	: D2	
Previous Run	: 36098B		Material	:	
Written By	:		Due Date	2/24/2008	Qty: 1 Um: Each
Checked & Approved By	: <u>KJ 08 01 18</u>				
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF				
	Est Rev:N 06.04.05 Added level21				EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick: 3/4"x3/4" 304/316 SS tube .063" wall	<u>FC 08 01 14</u>
		Batch: <u>M107514</u>	
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	<u>FC 08 01 14</u>
		1 D3166-3 Basket Hoop <u>1737613</u>	
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	<u>FC 08 01 14</u>
		1 D2506 Label Plate <u>1735585</u>	
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	<u>FC 08 01 14</u>
		2 D2327-1 Bushing <u>1736920</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 350/212/130 BASKET LID
Job Number: 36820A		Part Number: D2512
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-1 Hinge plate <u>B35689</u>		<i>FC 08 04 14</i>
6.0	D2581	Mounting Bracket
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2581 Mounting Bracket <u>B37298</u>		<i>FC 08 04 14</i>
7.0	M304EX07516F	Expanded Metal Flat Stai
Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s) Pick: Qty Part Number Description Batch 18 sf M304EX0.75-16F Expanded Metal <u>M107511</u>		<i>FC 08 04 14</i>
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 2-Cut (4) D2236 From D3166-3 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required		<i>FC</i> <i>FC</i> <i>FC</i> <i>FC</i> <i>FC 08 04 15</i>
9.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		<i>DO 08-04-16 ①</i>
10.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		<i>DO 08-04-16 ①</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:22 PM
User: Kim Johnston

Process Sheet

30 min

18/04/2008

S.061 08.34

#1 400.1 F

B236820-A

#3 F

D.2512. F

F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 36820A

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 POWDER COATING



POWDER COATING

Pressure wash FR 08/04/18

M107550

①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

M.F.

08/04/18

Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

M107230 paint

Batch: 106894 wing walk

13.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

LL



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0 PACKAGING 1



PACKAGING RESOURCE #1



08/04/18

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP

36 P20

C. 04/21/11

15.0 QC21



FINAL INSPECTION/W/O RELEASE



08/04/23 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M.F. 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPIED
SHEET 1 OF 4

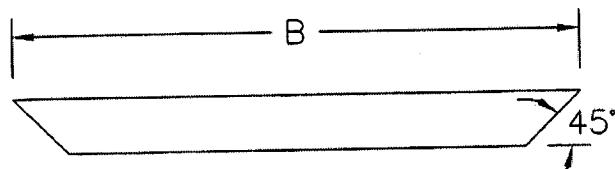
DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE NTS

RELEASED
01.04.27 *JP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	JP 03.01.20	ADD D2012-117 FOR D130-701-041
D2	JP 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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WORK ORDER
NO. *36820A*

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

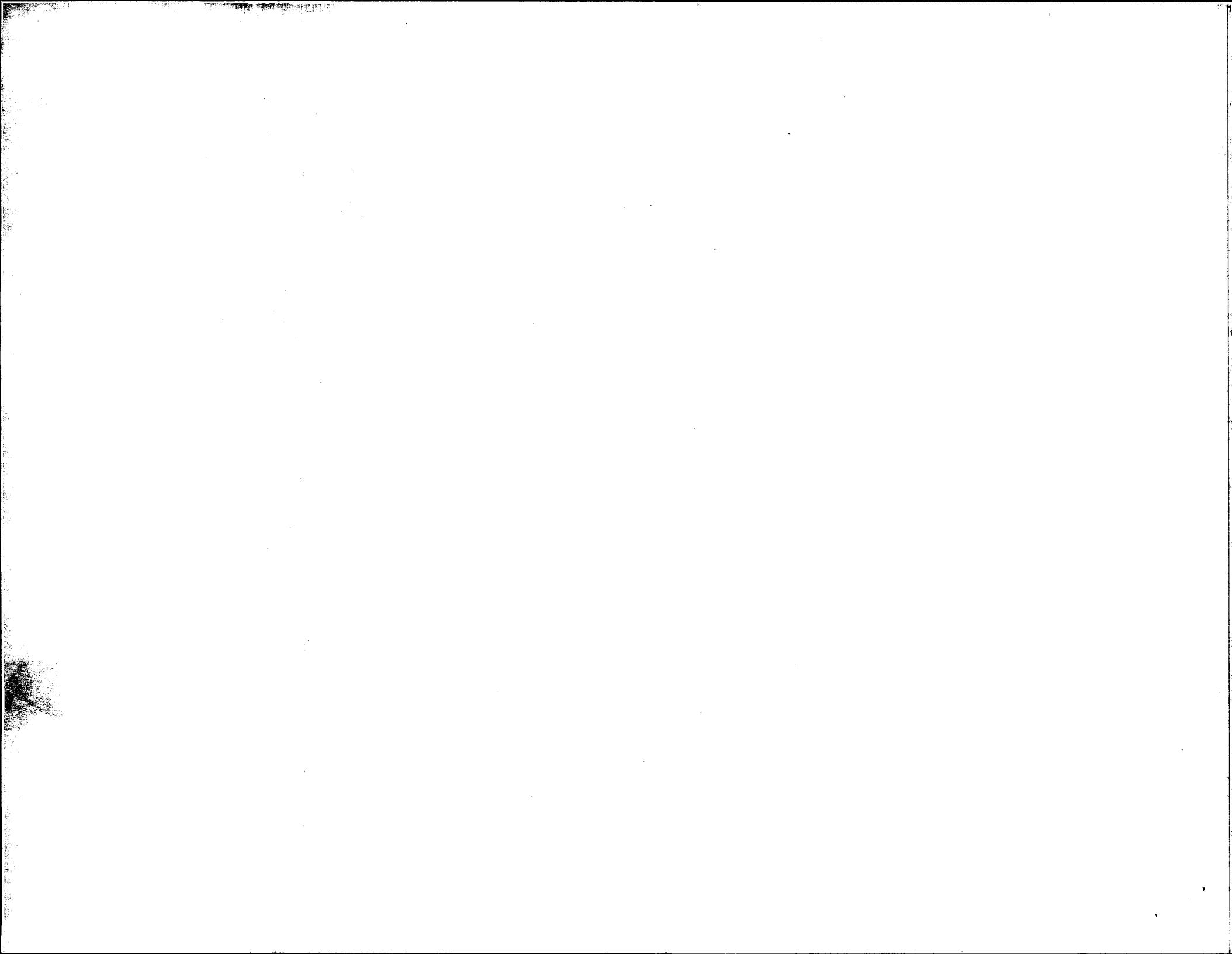
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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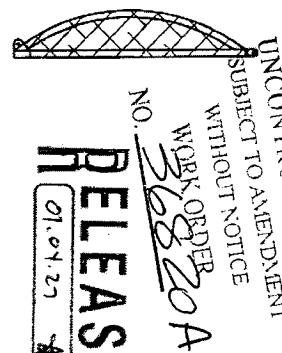
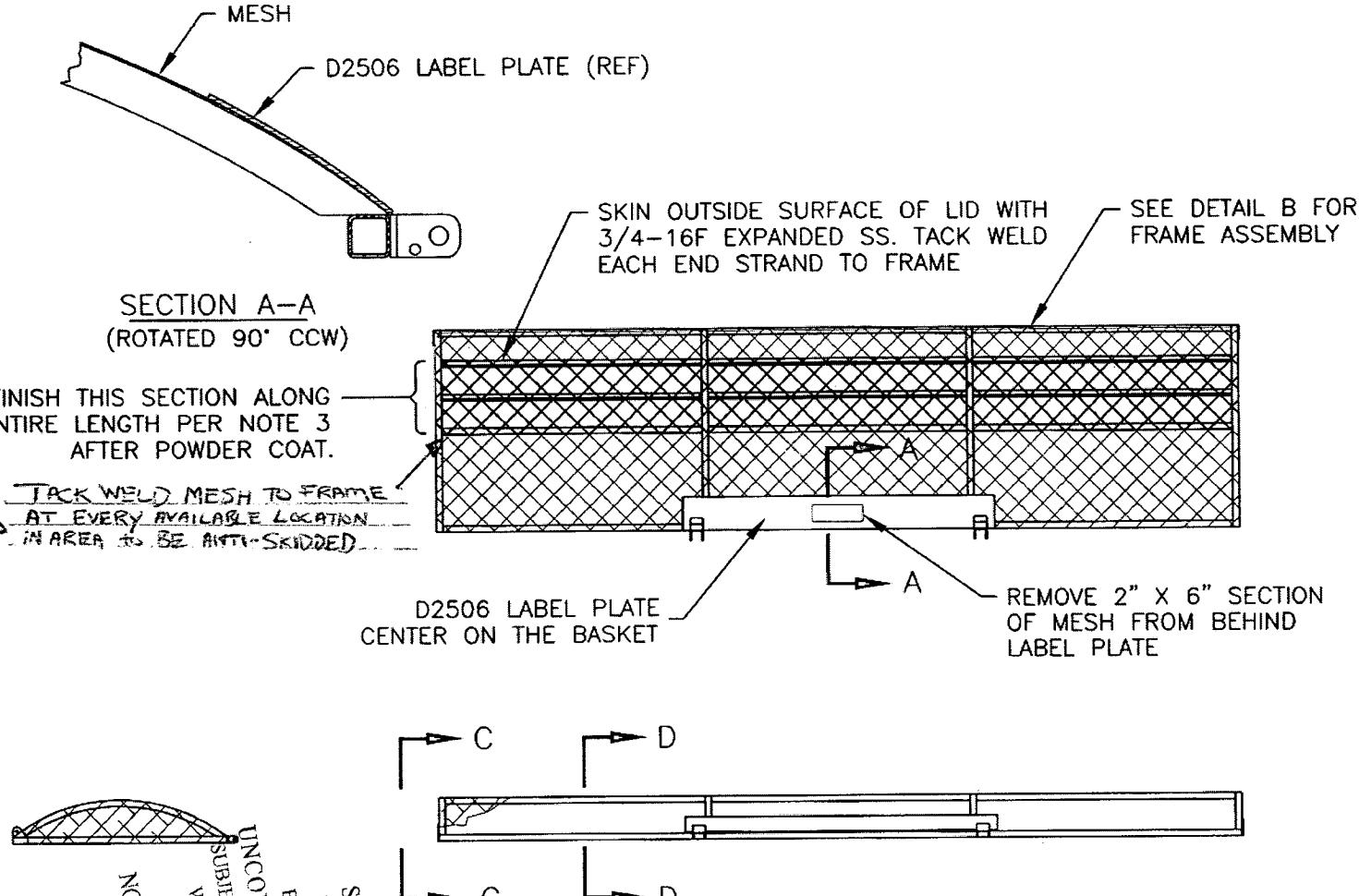
DART



DESIGN BW	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2512
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV. D SHEET 2 OF 4 SCALE 1:20

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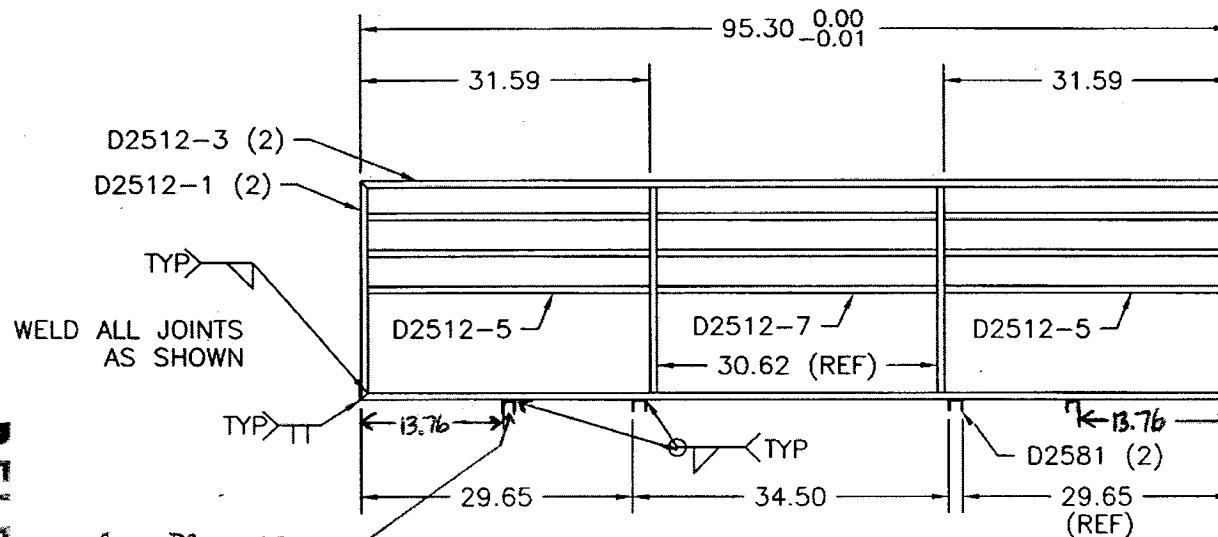
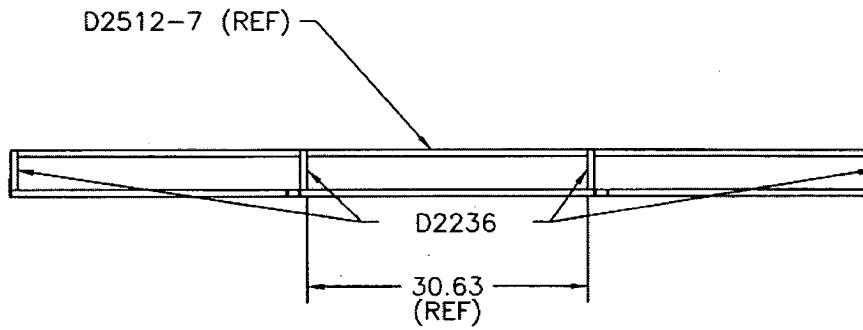
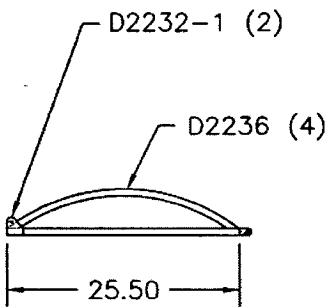
MESH MATERIAL: 3/4-16F EXPANDED SS
 FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) SPRAY PAINT BLACK INSIDE SURFACE
 APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES

01.04.19

RELEASED

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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2512	REV. D	SHEET 3 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)			SCALE 1:20



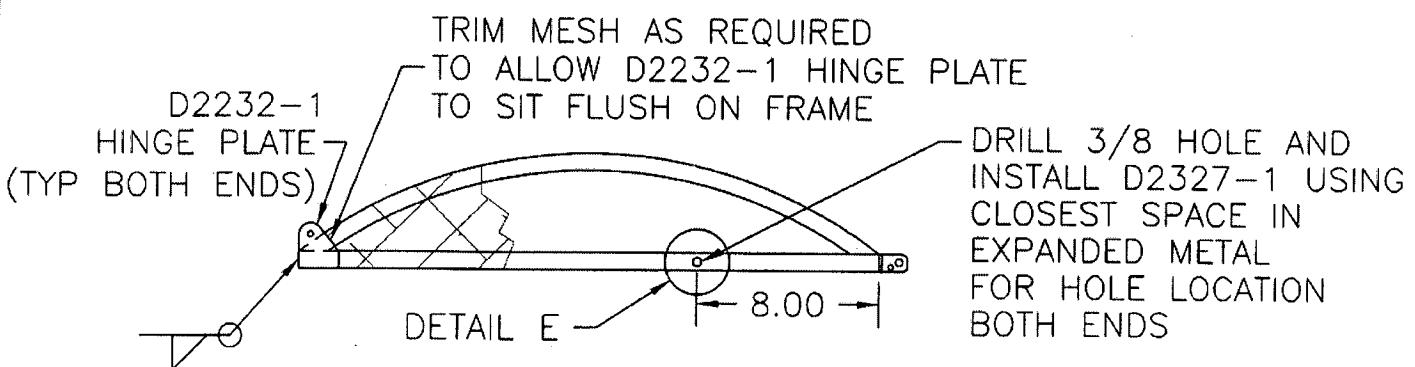
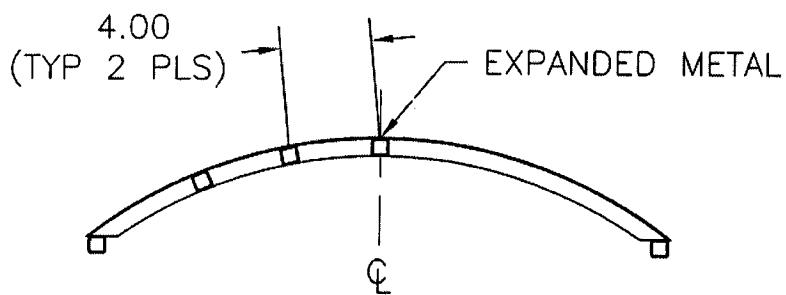
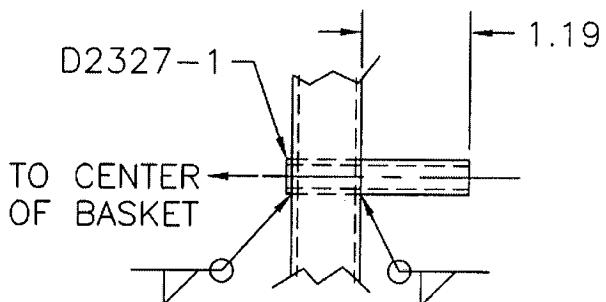
DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILAR BOTH END RIBS

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